

Work Order ID 66454



Page 1

Monday, February 28, 2011 12:34:57 PM

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 2/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 2.00



Customer: CU-DAR001

Reference: RMA RA111159 - RETURN

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev.D DEO-D1

100

0.00



DC

Document Control

Memo

0.00

CHG 002 Sub 6/22

for CL 11-6-21

110

0.00



QC

Quality Control

Memo

INSPECT RA111159

0.00

Sub 02/11

72

B59603/B60702
CHG 002/CHG 002

B66454

B66454

Work Order ID 66454

Monday, February 28, 2011 12:34:57 PM



Page 2

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 2.00

Customer: CU-DAR001

Reference: RMA RA111159

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

checked

0.00

-REMOVE ALL X-BOLT SPACERS

-DEBURR ALL HOLES PROPERLY

-PREP (ONE) HOLE FOR SWAGING
CALL CHRIS P FOR ACCEPTANCE OF HOLES BEFORE AND AFTER
SWAGING
IF APPROVED, PROCEED WITH PREP AND SWAGING OF ALL HOLES.

130

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

QC Memo

W06/06
0.00

(+2)

*Prep per QStoos & weld crossbolt
spacers D2579 per drawing D2580, D2504
For D2579 spacers, weld one
side, pass 3/8" drill, weld other side
pass 3/8" drill A/R Alum rod B
Count bore crossbolt spacers to 7/16" ID x 1.0"
deep as per drawing, deburr holes*

BB 11/05/30

117456

*REMOVED
BB 11/05/27*

702 FROM AFT END # 1, 2, 3, 4, 17, 18, 19, 20.

603 FROM AFT END # 1, 2, 3, 4, 16, 17, 18, 19, 20

Work Order ID 66454

Monday, February 28, 2011 12:34:57 PM



Page 3

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 2.00



Customer: CU-DAR001

Reference: RMA RA111159

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

2 0 11/10/14

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30
320 OF
4:00

2x 0 m-11/06/15

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sublot 17



M116964

Work Order ID 66454

Monday, February 28, 2011 12:34:57 PM



Page 4

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 2.00



Customer: CU-DAR001

Reference: RMA RA111159

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M1117316

Sikaflex expire date: 12/05

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M1117396

Sikaflex expire date: 12/05

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M1117863

2 4.34 110617

Work Order ID 66454

Monday, February 28, 2011 12:34:57 PM



Page 5

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/16/2011 Req'd Qty: 2.00



Customer: CU-DAR001

Reference: RMA RA111159

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sub 17



Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

190

0.00



Packaging

Memo

0.00

Packaging

REPACKAGE PER PPP
USING NEW B/N
NEW LABELS & PAPERWORK REQ'D
Identify and pack for shipping as per PPPD205-634-041
Location: _____
PPP Rev: _____

CHG 0002

11/6/22 SP

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/22 JF
ME
11-06-22

Picklist Print

Monday, February 28, 2011 12:34:54 PM

Page 1

Work Order ID: 66454

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 2/15/2011

Required Date: 2/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
 KJ IPP Rev P 10.02.19
 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
 10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No				Each	1,786.000		100			
Insert													

Location

Loc Qty

Loc Code

FP	21	M 117717	x500
115079	21		
ST282	1765		
111529	32		
113238	17		
115502	500		
115581	216		
116800	1000		

AN3-5A

Purchased

No



Bolt

Each

713.0000

4



Location

Loc Qty

Loc Code

ST350	713		
115016	47		
115371	500		
116632	166		

Picklist Print

Monday, February 28, 2011 12:34:54 PM

Page 2

Work Order ID: 66454

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 2/15/2011

Required Date: 2/16/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C4A Purchased No
BOLT

Each 2,764.000 100

Location

Loc Qty

Loc Code

ST350

2764

M117094

2100

115300

25

116075

337

116704

702

116924

1200

117010

500

AN960C10L NAS1149C0332 Purchased No

Each 61.0000 100

washer

Location

Loc Qty

Loc Code

ST245

61

107534

59

108246

2

AN960JD10L NAS1149D0332J Purchased No

Each 4.0000 4

Washer

Location

Loc Qty

Loc Code

ST335

4

11912

4

D205-634-041 Manufactured No

Each 0.0000 2

Replacement Skidtube

B59603/B60702

Monday, February 28, 2011 12:34:54 PM

Shop Packet Print

Page 2

Picklist Print

Monday, February 28, 2011 12:34:54 PM

Work Order ID: 66454

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 2/15/2011

Required Date: 2/16/2011

Start Qty: 2.00

Required Qty: 2.00

D2594-1

Manufactured No

Each

327.0000

32



Plug, 205 Skidtube



24 2106116

Location

Loc Qty

Loc Code

FP

183

42807

112

1366932

X32

55002

71

FP14

144

58434

15

65980

129

D2594-3

Manufactured No

Each

1,031.000

32



O-Ring, 205 Skidtube



24 2106116

Location

Loc Qty

Loc Code

FP

543

55546

19

58191

12

59358

12

65518

500

fpa

488

61762

488

1366952

X32

Picklist Print

Monday, February 28, 2011 12:34:54 PM

Page 4

Work Order ID: 66454

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 2/15/2011

Required Date: 2/16/2011

Start Qty: 2.00

Required Qty: 2.00

D2855 Manufactured No

Each 77.0000

2



isl 11/06/16

Cap

Location

Loc Qty

Loc Code

FP6

1

56613

1

ST026

76

50513

1

50770

28

51539

2

53791

10

65569

35

x2

D3564-11 Manufactured No

Each 11.0000

2



isl 11/06/16

Wearshoe

Location

Loc Qty

Loc Code

FP019

11

65159

11

369119

x2

D3564-13 Manufactured No

Each 37.0000

2



isl 11/06/16

Wearshoe

Location

Loc Qty

Loc Code

FP16

14

65522

14

FP17

23

59660

1

66136

22

1366805

x2

Monday, February 28, 2011 12:34:55 PM

Shop Packet Print

Page 4

Picklist Print

Monday, February 28, 2011 12:34:55 PM

Work Order ID: 66454



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/15/2011

Required Date: 2/16/2011

Start Qty: 2.00

Required Qty: 2.00

D3564-5 Manufactured No

Each 30.0000

2



Wearshoe

21106116

Location

Loc Qty

Loc Code

FG 34806

1 1

B6B960

x2

FP19 57525 58709

2 1 1

FP-19 63575 65523 66148

27 1 11 15

16.0000

2

D3564-9 Manufactured No

Each



Wearshoe

21106116

Location

Loc Qty

Loc Code

FP 55334

1 1

B6B349

x2

FP019 66153

12 12

FP19 62238

3 3

33.0000

4

D3566-1 Manufactured No

Each



Gasket

21106116

Location

Loc Qty

Loc Code

FP015 57715 66040 66129

33 1 20 12

B6B924

4

Picklist Print

Monday, February 28, 2011 12:34:55 PM

Work Order ID: 66454

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 2/15/2011

Required Date: 2/16/2011

Start Qty: 2.00

Required Qty: 2.00

D3566-13 Manufactured No

Each 32.0000

2



Gasket



M l ulouals

Location

Loc Qty

Loc Code

FP014

32

B6834C

x2

64070

15

66137

17

D3566-5 Manufactured No

Each 13.0000

2



Gasket



M u l o u a l s

Location

Loc Qty

Loc Code

FP015

13

B6896C

x2

63574

1

66146

12

~~D4202-1~~ *D2579* Manufactured No

Each 367.0000

40



Spacer



Location

Loc Qty

Loc Code

LG

367

65529

146

66121

221

BE11/05/30

B 68737 x17

DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 #**DEO ATTACHED**

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

D2580-1 DRILLING DETAIL

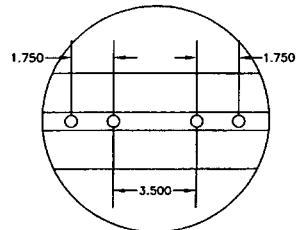
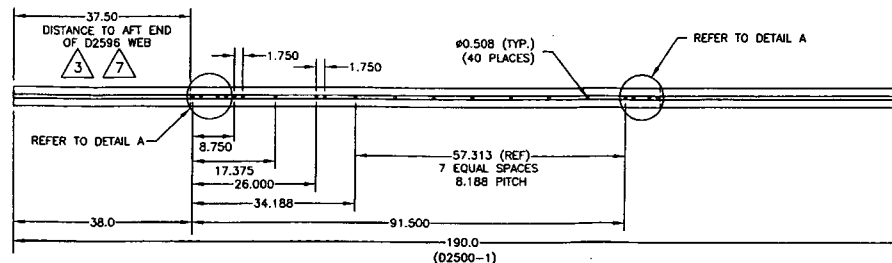


Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

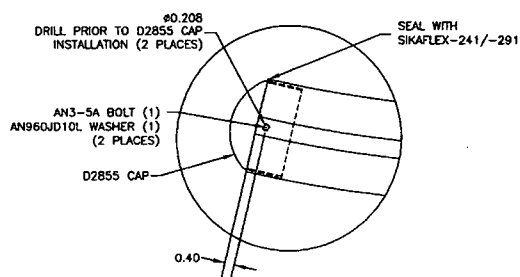
- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576



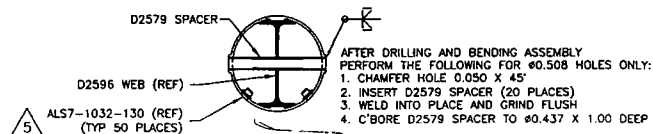
RELEASED
07-06-28

DEO ATTACHED

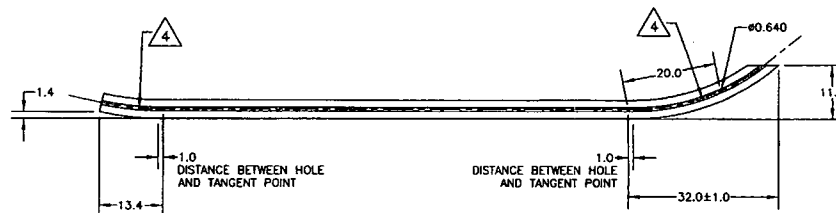
DETAIL C
SCALE 5:24



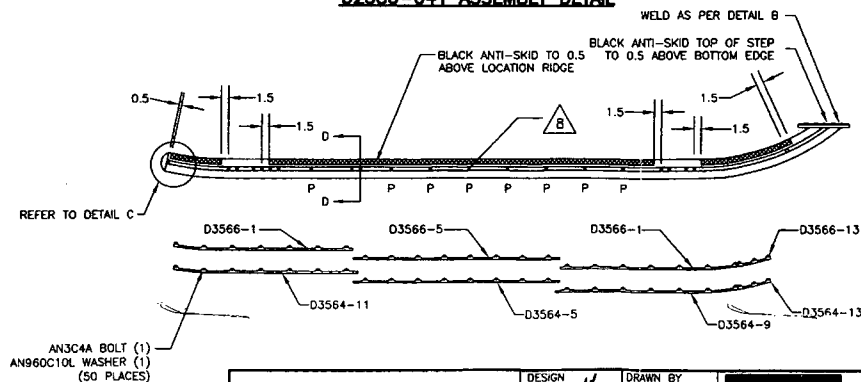
SECTION D-D
SCALE 5:24



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

COPYRIGHT © 1998 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN

DRAWN BY

CHECKE

APPROVED	
----------	--

DATE _____

III

07.02.27

205 SKIDTUBE ASSEMBLY

DART DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

DRAWING NO.	REV. D
D2580	SHEET 2 OF 3

TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

RELEASED
07 Dec 78

Diagram illustrating the underside of a propeller with grinding locations marked:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{8}$

DETAIL G
SCALE 5:24

Technical drawing of a circular component with the following annotations and dimensions:

- Annotations:**
 - DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
 - SEAL WITH SIKAFLEX-241/-291
 - AN3-5A BOLT (1)
 - AN960J010L WASHER (1) (2 PLACES)
 - D2855 CAP
 - SEE NOTE ii)
- Dimensions:**
 - 0.208
 - 0.40

D2575 SPACER

D2596 WEB (REF)

AL57-1032-130 (REF)
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

37.50
DISTANCE TO AFT END
OF D2596 WEB
38.0
REFER TO DETAIL A
1.750
1.750
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
91.500
190.0
(D2500-1)
Ø0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL E

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

NO C'BORE NO PLUG

NO C'BORE NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN56OC10L WASHER (1)

(50 PLACES)

DESIGN

DRAWN BY

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>
CHECKED <i>HA</i>	APPROVED <i>HA</i>
DATE 07.02.27	

 DART AEROSPACE LTD. HAINESBURY, ONTARIO, CANADA	
DRAWING NO. D2580	REV. D SHEET 3 OF 3
TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

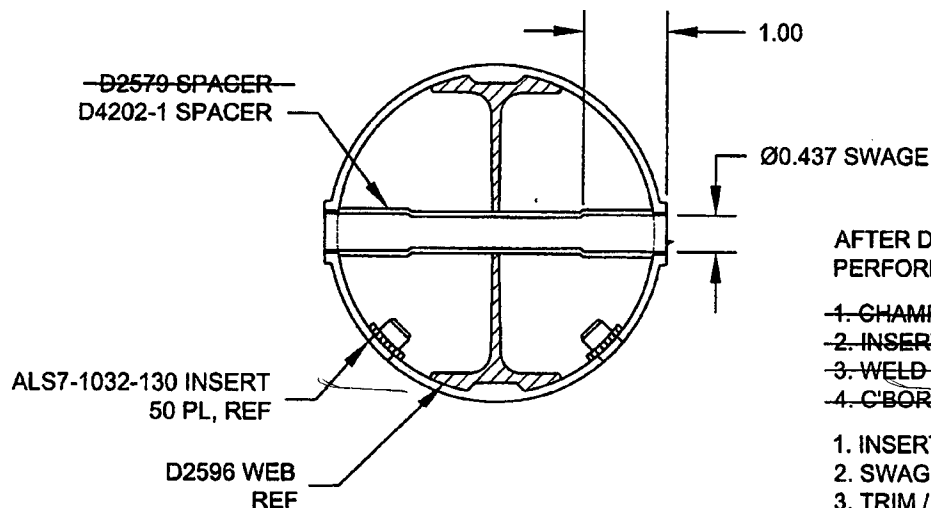
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



NO. 251

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 68708-68708
Part number: 205-634-041
Description: 205
Welding Process: Tig[] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[] fail[]
Penetration: pass[] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap): pass[] fail[]
Porosity (surface): pass[] fail[]
Coloration: pass[] fail[]

Qualifier Ratz Evers Date of Test Coupon 11-05-05

Welder Barclay Elliott Date of Test Coupon 11-05-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Linda Lacelle

From: Mike Petsche <mpetsche@dartaero.com>
Sent: February 28, 2011 11:42 AM
To: 'Linda lacelle'
Subject: FW: RA111159 Expedition Heli D205-634-041 rework

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: February 24, 2011 10:51 AM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; Linda lacelle
Subject: RE: RA111159 Expedition Heli D205-634-041 rework

Same here. Great!

Here you go Linda.

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com
DART Aerospace Ltd.
613-632-5200

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, February 24, 2011 10:39 AM
To: 'Jason Murdoch'
Cc: 'Mike Petsche'
Subject: RE: RA111159 Expedition Heli D205-634-041 rework

I would create the w/o, I'm not expecting any problems.

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: February 24, 2011 10:29 AM
To: 'Chris Provencal'
Cc: 'Mike Petsche'
Subject: RE: RA111159 Expedition Heli D205-634-041 rework

Shouldn't be a problem. Are we safe to create a w/o before starting? Then you guys can have a look.

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com
DART Aerospace Ltd.
613-632-5200

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, February 24, 2011 10:01 AM
To: Jason Murdoch

Cc: 'Mike Petsche'

Subject: RE: RA111159 Expedition Heli D205-634-041 rework

Please proceed with swaging the x-bolt spacers. My only concern is the hole is properly deburred with no sharp edges. Can we prep one of the holes for swaging? I'd like to see one of the holes before and after swaging.

-Chris

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]

Sent: February 24, 2011 8:49 AM

To: 'Mike Petsche'

Cc: Linda Iacelle

Subject: RA111159 Expedition Heli D205-634-041 rework

Good morning,

Expedition returned 2 D205-634-041 skidtubes, batch's B59603 & B60702. The x-bolt spacers were cracked on the insides at the saddle locations. These were never flown. The cracking is an unfortunate result of our old process of welding & counter boring.

Based on the fact that the hole sizes in the x-bolt spacer locations are the same size needed for swaging, & by drilling the x-bolts out will remove 90% of the weld that maybe inside, I think we can get away with reworking these tubes to include the new swaged x-bolt spacers, without interfering with the original process.

Please advise if this is acceptable.

Jason Murdoch

Quality Coordinator

jmurdoch@dartaero.com

DART Aerospace Ltd.

613-632-5200

Linda Lacelle

From: Jason Murdoch <jmurdoch@dartaero.com>
Sent: February 24, 2011 8:49 AM
To: 'Mike Petsche'
Cc: Linda lacelle
Subject: RA111159 Expedition Heli D205-634-041 rework

Follow Up Flag: Follow up
Due By: February 24, 2011 4:00 PM
Flag Status: Flagged

Good morning,

Expedition returned 2 D205-634-041 skidtubes, batch's B59603 & B60702. The x-bolt spacers were cracked on the insides at the saddle locations. These were never flown. The cracking is an unfortunate result of our old process of welding & counter boring.

Based on the fact that the hole sizes in the x-bolt spacer locations are the same size needed for swaging, & by drilling the x-bolts out will remove 90% of the weld that maybe inside, I think we can get away with reworking these tubes to include the new swaged x-bolt spacers, without interfering with the original process.

Please advise if this is acceptable.

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com
DART Aerospace Ltd.
613-632-5200